

# Work Order ID 62428

September 30, 2010 7:59:49 AM



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Item ID: D4172-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Angle

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/9/30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4172

A

0.00

*M-1 10/09/30*

100



Small Fab

Small Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Use DT9658 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes



110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*8.10.10.06*



-4

*PK ->*

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*BF 10-10-6*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4172-4 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 62428		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.01	100.2	HOLE SERIES PER DETAIL A SHIFTED BY 0.030" ON THE 5.500" DIA (CB-6). RC: JIG NOT PROPERLY PREPARED AT THE END STOPPER. FLASH OF WELDING PREVENTING FROM LOCATING PART CORRECTLY.		THIS DEVIATION IS ACCEPTABLE ON THE BASIS THAT <del>THESE</del> ALL THE HOLES ARE STILL WITHIN <del>THE</del> 0.010" FROM	M-A 10/10/05	S 10/10/06		S 10/10/01
			0.10.09	BUSH OTHER, FOR DRAWING. FURTHERMORE, THERE IS ENOUGH PLAY IN THE NOTPLATES TO COMPENSATE.		S 10/10/06	10.10.09 QS1042	S 10/10/05
10/10/01	± 100	Found at inspection that Dim .563 was measuring from one end .553 and the other .583 R.C. Jig is off.	10.10.04	SCRAP PARTS. CORRECT OR MAKE NEW DRILLING JIG PRIOR TO MAKING REPLACEMENT FOR SCRAPPED PARTS.	10.10.04 M-A 10/10/05	S 10/10/06	10.10.04	S 10/10/01

NOTE: Date & initial all entries

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Item ID: D4172-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Angle

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00

7/11

10/10/06

1

0

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 211A

0.00



Packaging

Memo

0.00

Packaging

10/10/06 SP

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/06

ME

10-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 62428



Parent Item: D4172-4



Parent Item Name: Support Angle

Start Date: 9/30/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	90.9100	6.25	6.578947			
6061T6 ANGLE 1.00 x 1.00 x .125W													



M-1 10/04/30

Location

MAT

115688 ✓

115776

Loc Qty

90.91

10.91

80

Loc Code

6.578947

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

